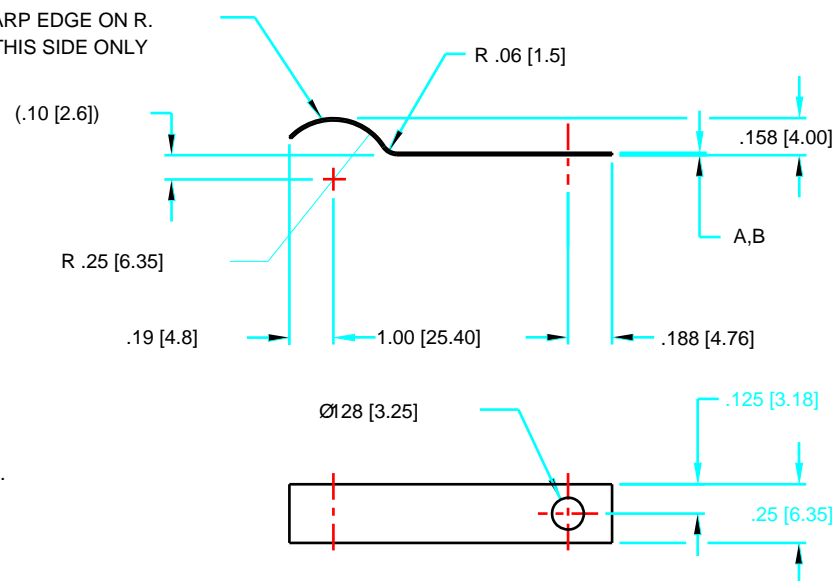


&lt; B)

PLOT SCALE: 2=1

DWG. SCALE: .5

A2336700

BREAK SHARP EDGE ON R.  
THIS SIDE ONLY

## NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
3. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOWDOWN.
4. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
6. SURFACE ROUGHNESS  $\sqrt{63}$

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

B		.020 [0.50] THK		1
A		.010 [0.25] THK		1
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A2336700	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
TOLERANCES		DRAWN BY J.GOGOL	DATE 9/14/95	CHIEF DESIGN ENGINEER
DECIMALS		CHECKED BY		GP. LEADER
ANGULAR		DESIGNER J.GOGOL	9/14/95	PROJECT MGR.
SURFACE ROUGHNESS $\sqrt{63}$		RESPONSIBLE ENGINEER		APPROVED/RELEASED
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.		TITLE ADVANCED PHOTON SOURCE		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMSI 144		X1-84 2ND CRYSTAL HOLDER FOR 3-ID-A KOHZU SINGLE SPRING		
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST AMSI 114.3		MATERIAL 440 STAINLESS STL HARDEN TO 35 Rc		
DO NOT SCALE DRAWING		SCALE 2:1	SHEET 1 of 1	DRAWING NUMBER B P4105091103-840009-00